

ABSTRACT OF THE DISCLOSURE

A screw is rotated at a set speed and retreated by performing back pressure control for keeping a resin pressure at a set pressure. When the retreat position of the screw reaches a change point set nearby a set metering completion position, the back pressure control for keeping the resin pressure at a set resin pressure is stopped. A command for positioning the screw at a metering completion position is output to position the screw at the metering completion position. At the same time, when a screw position reaches the change point, the screw is reversed by a set value at a set speed.